

Date: Thursday, 27/11/2008 2:23:36 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 43803		
Estimate Number	: 11010		
P.O. Number	:	Part Number	: D2649
This Issue	: 27/11/2008 S.O. No. :	Drawing Number	: D2649 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 43505	Material	:
Written By	:	Due Date	: 10/12/2008 Qty: 300 Um: Each
Checked & Approved By	: <u>540 08.11.27</u>		
Comment	: Est F 02.03.26 Added turning on Cobra NC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W058	6061-T6 RD Tube .375 x.058W
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Comment: Qty.: 0.2975 f(s)/Unit Total: 89.2395 f(s)

6061-T6 Tube .375 x.058W

Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall

Batch M107514 - 12 ft  
M109314 - 41.2395  
M108380 - 36 ft 300 pcs 08/11/29

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA214 on cobra machine. 08/11/29

300 pcs

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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08/11/29

300 pcs

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.2 08/11/30

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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300 pcs

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location BACThey

8/12/1

50

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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08/12/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



WVF 08-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

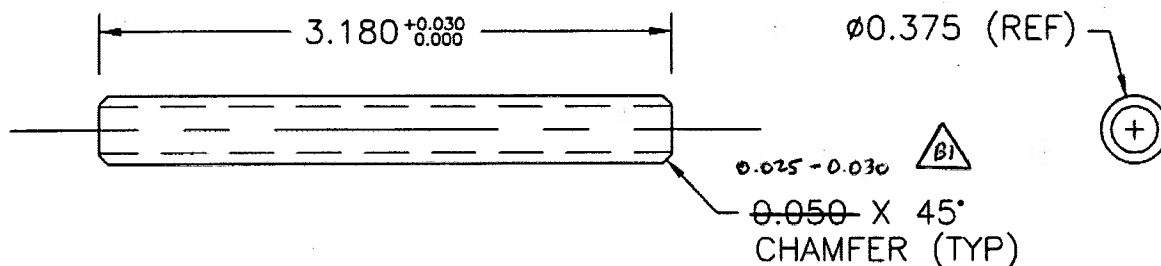
**NOTE:** Date & initial all entries





DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
BI	<del>#</del> CP 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED  
98.01.20 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43803

MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)  
0.375 DIA 0.058 WALL  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED